

Work Order ID 79945

79945

Page 1

February-08-12 8:03:42 AM

Item ID: D4151-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 08/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: HLS

Date: 12/02/08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4151	C

100		0.00
100		
Small Fab	Memo	0.00
Small Fab	1- Assemble as per dwg	

[Handwritten signature]
12/02/08 (1)

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

[Handwritten signature]
12/02/08

(71)

120	Identify as per dwg & Stock Location <u>134</u>	0.00
120		
Packaging	Memo	0.00
Packaging		

[Handwritten signature]
12/2/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79945***79945***

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00


130

QC

Memo

0.00

Quality Control

M.C.J. 12/02/09 M.C.J.
12/02/09
(1)

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Picklist Print

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Parent Item: D4151-043

D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 08/02/2012

Required Date: 15/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.01.21 as per dwg revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-3 *D4151-3* Upper Hardpoint Plate		Manufactured	No			100	Each	9.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				9					
					76305			9					
D4151-7 *D4151-7* Fwd Eyebolt Receiver (Upper)		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				1					
					73049			1					
AN4C13A *AN4C13A* BOLT		Purchased	No			100	Each	190.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				190					
					120187			1					
					120423			189					

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Picklist Print

February-08-12 8:03:47 AM

Page 2

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Parent Item: D4151-043

D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 08/02/2012

Required Date: 15/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,840.000

2

2

MS21043-4

**

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

353

118686

353

ST301

1447

119546

447

120308

1000

NAS1149C0432R

Purchased

No

100

Each

3,256.000

4

4

NAS1149C0432R

**

Washer

Location

Loc Qty

Loc Code

ST297

3256

117291

2256

119124

1000

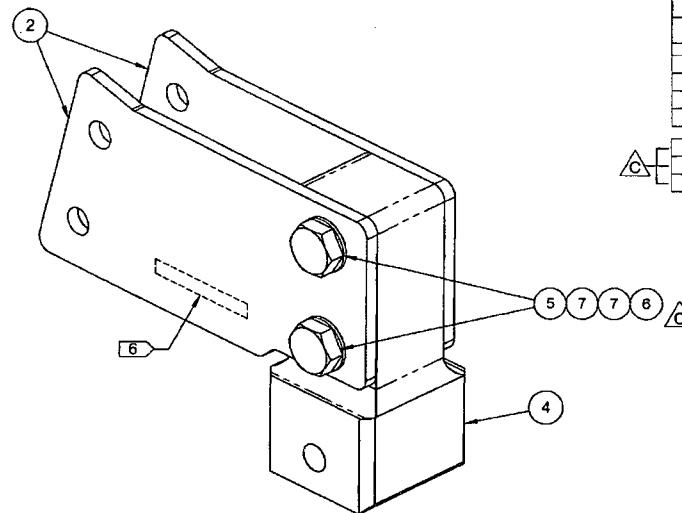
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

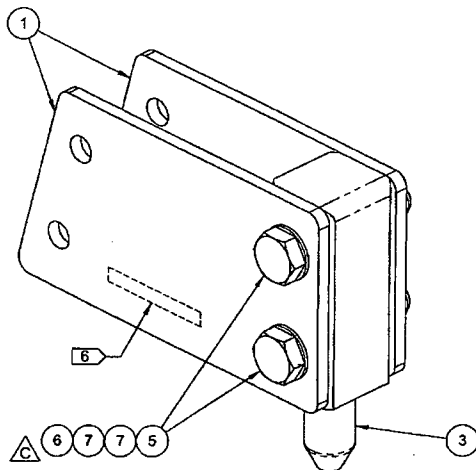
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D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

RELEASED
2011-01-18

C	AN4 HARDWARE WAS AN3 (B8-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-787 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3811-1 (ZN B6-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2) REASON: SEE TR-D380-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3

TITLE **BASKET FWD HARDPOINT** SCALE NTS

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79945 M.L.J
12/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

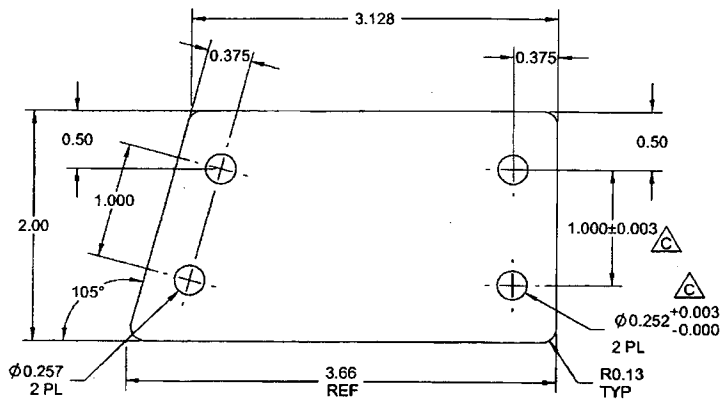
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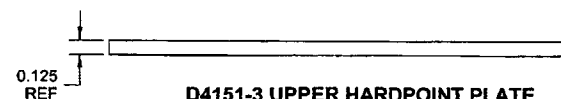
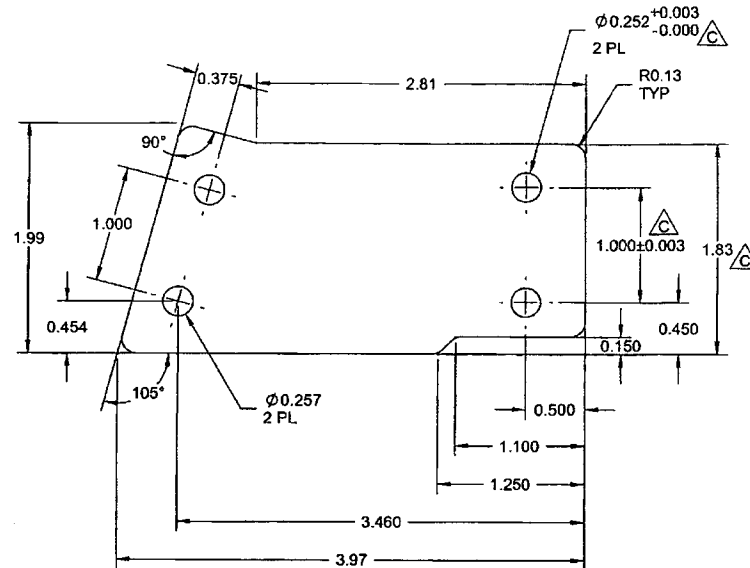
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D4151-1 LOWER HARDPOINT PLATE



D4151-3 UPPER HARDPOINT PLATE

RELEASED
2011-01-08
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED	MA	TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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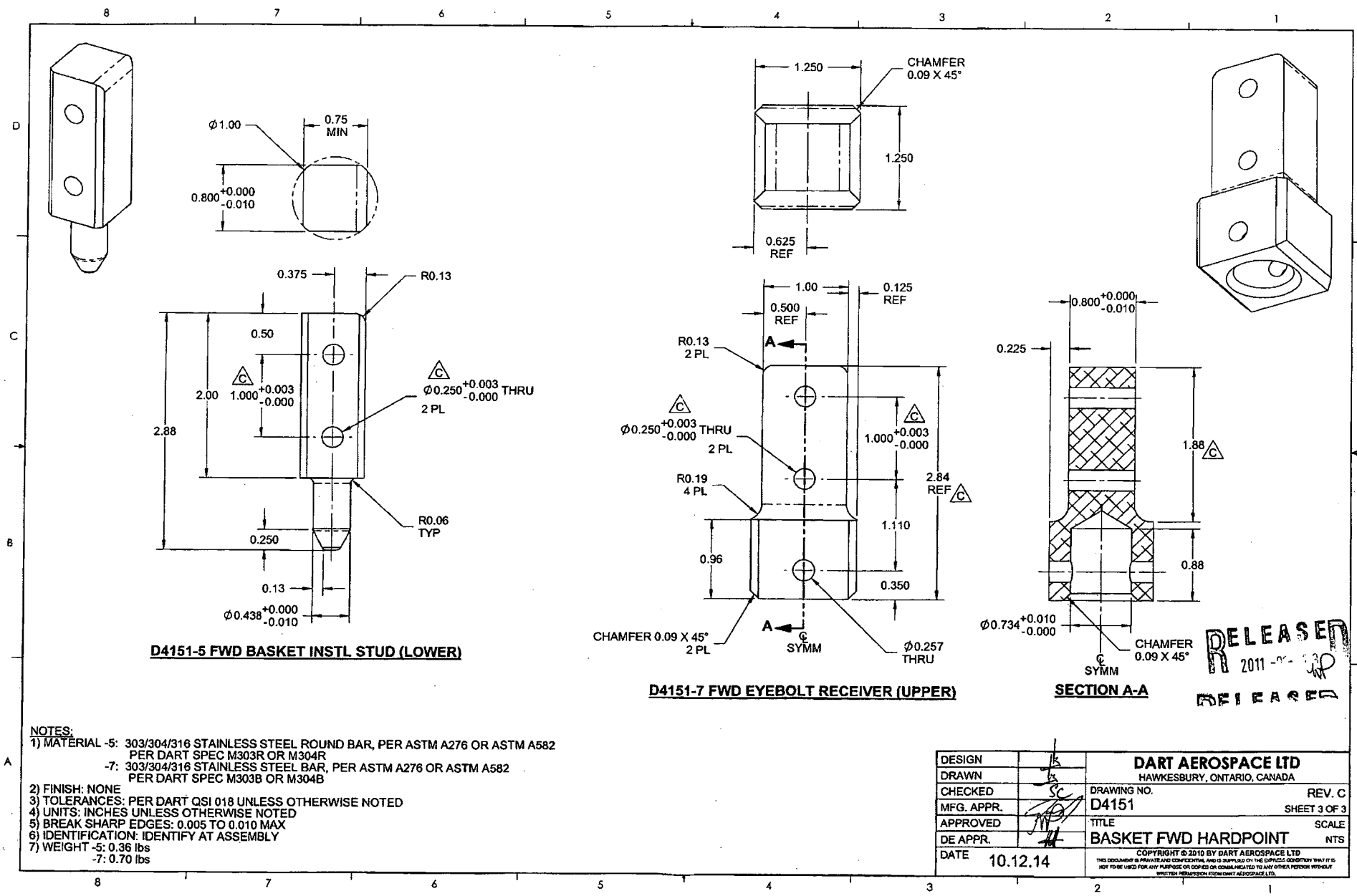
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D4151-5 FWD BASKET INSTL STUD (LOWER)

D4151-7 FWD EYEBOLT RECEIVER (UPPER)

SECTION A-A

- NOTES:**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE NTS
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RELEASED
R 2011-01-13
RELEASED

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